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United States  
Department of  
Agriculture

Food Safety  
and Inspection  
Service

Field  
Operations

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# Meat and Poultry Inspection Regulations

## Change 97-1



## CHANGE TRANSMITTAL SHEET

☐ DIRECTIVE  
☐ REVISION  
☐ AMENDMENT  
☒ OTHER

CHANGE 97-1  
MEAT AND POULTRY INSPECTION REGULATIONS

97-1

3/10/97

### I. PURPOSE

This document transmits changes to Part 381 of the MPI Regulations. These changes were published in the Federal Register on February 4, 1997 (62 FR 5139, Docket No. 94-016F), titled Poultry Inspection: Revision of Finished Product Standards with Respect to Fecal Contamination.

### II. CHANGES

#### SUBCHAPTER C - MANDATORY POULTRY PRODUCTS INSPECTION

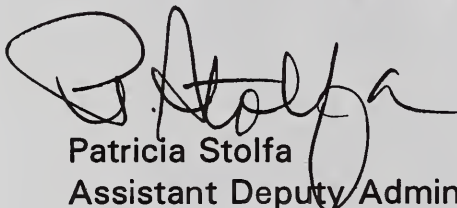
##### Remove

Pages 33, 34, 46h, 46i, 45j, and,  
46k

##### Insert

Pages 33, 34, 46h, 46i, 46j,  
46k and 46k(1)

**EFFECTIVE DATE: 5/5/97**



Patricia Stolfa  
Assistant Deputy Administrator  
Office of Policy, Program Development, and Evaluation

Attachment

This covers changes effective as of May 5, 1997.





§ 381.60(a)(2) continued)

for use and the precautions, if any, necessary in the use of such compound for the purpose intended in poultry processing establishments.

(b) As a prerequisite for approval, any compound which is required to be registered under the provisions of the Federal Insecticide, Fungicide, and Rodenticide Act shall be registered and comply with the provisions of that Act. The applicant shall furnish the registration number assigned under the aforesaid Act along with two copies of the label being currently used on the product.

(c) A small sample of the compound (4 to 6 ounces) shall be submitted with the request for approval of its use in poultry processing establishments.

(d) The Administrator will either approve or disapprove the use of a particular compound after a careful evaluation of the data submitted pursuant to paragraph (a) of this section and consideration of any other information that is available pertaining to the compound under consideration.

(e) The Inspection Service is authorized to draw samples of any compound used in any official establishment and make analyses of such compound to determine if the compound conforms to that originally approved and if it is satisfactory for use in official establishments under this section. Whenever the Administrator has reason to believe that a compound may have a deleterious effect on poultry or poultry products, the approval of the particular compound may be suspended, and in such case the processor shall be given an opportunity to show that the compound does not have such effect. After such opportunity has been afforded to the processor, the Administrator shall make a determination as to the effect of the compound on poultry and poultry products and withdraw or reinstate the approval of the compound accordingly. Use of the compound shall not be permitted during the period of suspension.

§ 381.61 Cleanliness and hygiene of official establishment personnel.

(a) No official establishment shall employ, in any department where any poultry product is processed or otherwise handled, any person showing evidence of a communicable disease in a transmissible stage or known to be a carrier of such disease, or while affected with boils, sores, infected wounds, or other abnormal sources of microbiological contaminants.

(b) All persons coming in contact with exposed poultry products, or poultry products handling equipment shall wear clean garments and suitable head coverings to prevent hair from falling into poultry products; and shall keep their hands and fingernails clean at all times while thus engaged.

(c) Every person shall wash his hands thoroughly after each use of toilet or change of garments before returning to duties that require the handling of dressed poultry or other poultry products or containers thereof, or poultry product handling equipment.

(d) The use of tobacco in any form, the eating of food, or any other personal habit which may result in adulteration of any poultry product shall not be permitted in any room where exposed dressed poultry or other poultry products are being processed or otherwise handled.

#### Subpart I-Operating Procedures

#### § 381.65 Operations and procedures, generally.

(a) Operations and procedures involving the processing, other handling, or storing of any poultry product shall be strictly in accord with clean and sanitary practices and shall be conducted in such a manner as will result in sanitary processing, proper inspection, and the production of poultry and poultry products that are not adulterated.

(b) Materials which create any condition that may result in adulteration of poultry products shall not be handled or stored in rooms, compartments, or other places in any official establishment where any poultry product is processed, otherwise handled, or stored.

(c) Poultry shall be slaughtered in accordance with good commercial practices in a manner that will result in thorough bleeding of the carcasses and assure that breathing has stopped prior to scalding. Blood from the killing operation shall be confined to a relatively small area.

(d) Kidneys of mature chickens and mature turkeys (poultry defined in § 381.170(a)(1)(vi) and (vii) and (2)(iv)) shall be removed from their carcasses after the inspectors complete their post-mortem inspection of the poultry viscera, but before completion of the eviscerating operations, and shall not be used for human food.

(e) Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank.\*

(f)-(g) [Reserved]

(h) Thawing poultry in water:

(1) Ready-to-cook poultry. When frozen ready-to-cook poultry is to be thawed in water, the thawing practices and procedures shall be such as will prevent the product from becoming adulterated by the absorption of moisture and such poultry shall be thawed by one of the following methods:

(i) The poultry may be thawed in continuous running tap water of sufficient volume and for such limited time as is necessary to thaw such poultry. The thawing media shall not exceed 70° F. in temperature. Complete thawing is



TABLE 1  
DEFINITIONS OF NONCONFORMANCES

A Processing nonconformances.

1 Extraneous material  $\leq 1/16$ "

--Include any specks, tiny smears, or stains of material that measure  $1/16$ " or less in the greatest dimension.

\*  
EXAMPLES: Ingesta, \* \* \* unattached feathers, grease, \*  
bile remnants, and/or whole gall bladder or spleen, embryonic  
yolk, etc.

--Factor is one.

--1 to 5 = 1 defect; 6 to 10 = 2 defects; 11 or more = 3  
defects.

A maximum of three incidents per carcass.

2 Extraneous material  $>1/16$ " to 1"

--The same material as line 1, but measuring  $>1/16$ " to 1"  
in the longest dimension.

--Factor is one.

--A maximum of three incidents per carcass.

\* \* \*

\*

3 Extraneous material  $>1$ "

--The same material as lines 1 to 2, but measuring  
greater than one inch.

--Factor is two.

--A maximum of two incidents per carcass.

4 Oil glands remnant--less than two whole glands

--Recognizable fragment(s) of one or both oil glands  
equals one incident.

--Factor is one.

--Maximum of one incident per carcass.

5 Oil glands - two whole glands.

--Both whole oil glands with no missing fragments equals  
one incident. If the oil glands are cut, but no fragment  
is removed, consider them to be whole. But if even a  
small fragment is removed, use line 4.

--Factor is two.

--A maximum of one incident per carcass.

(§ 381.76(b)(3) continued)

6 Lung  $\geq$  1/4" whole

--Any portion less than a whole lung, and equal to or greater than 1/4" at the greatest dimension, equals one incident.

--Factor is one.

--A maximum of two incidents per carcass.

7 Lung--whole

--Each whole lung equals one incident.

--Factor is two.

--A maximum of two incidents per carcass.

\*

\* \* \*

\*

8 Intestine

--Any identifiable portion of the terminal portion of the intestinal tract with a lumen (closed circle) present, or split piece of intestine large enough to be closed to form a lumen.

--Factor is five.

--A maximum of one incident per carcass.

9 Cloaca

--Any identifiable portion of the terminal portion of the intestinal tract with mucosal lining.

--Factor is five.

--A maximum of one incident per carcass.

10 Bursa of Fabricius

--A whole rosebud, or identifiable portion with two or more mucosal folds.

--Factor is two.

--A maximum of one incident per carcass.

11 Esophagus

--Any portion of the esophagus with identifiable mucosal lining.

--Factor is two.

--A maximum of one incident per carcass.

(§ 381.76(b)(3) continued)

12 Crop--partial--with mucosa

--Any portion of the crop that includes the mucosal lining.

--Factor is two.

--A maximum of one incident per carcass.

13 Crop--whole

--Any complete crop.

--Factor is five.

--A maximum of one incident per carcass.

14 Trachea  $\leq 1$ "

--Identifiable portion of trachea less than or equal to one inch long.

--Factor is one.

--A maximum of one incident per carcass.

15 Trachea  $> 1$ "

--Identifiable portion of trachea greater than one inch.

--Factor is two.

--A maximum of one incident per carcass.

16 Hair  $\geq 1/4$ " 26 or more

--Hair which is one-fourth inch long or longer measured from the top of the follicle to the end of the hair. 26 or more hairs equal one incident.

--Factor is one.

--A maximum of one incident per carcass.

17 Feathers and/or Pinfeathers  $\leq 1$ "

--Attached feathers or protruding pinfeathers less than or equal to one inch long. Scored 5 to 10 per carcass as one incident, 11 to 15 per carcass as two incidents, and 16 or more as three incidents.

--Factor is one.

--A maximum of three incidents per carcass.

(§ 381.76(b)(3) continued)

18 Feather >1"

--Attached feathers longer than one inch. Scored 1 to 3 per carcass as one incident, 4 to 6 per carcass as two incidents, and 7 or more as three incidents.

--Factor is one.

--A maximum of three incidents per carcass.

19 Long Shank--both condyles covered

--If the complete tibiotarsal joint is covered, it equals one incident.

--Factor is two.

--A maximum of two incidents per carcass.

B Trim nonconformances.

1 Breast blister

--Inflammatory tissue, fluid, or pus between the skin and keel must be trimmed if membrane "slips" or if firm nodule is greater than 1/2" in diameter (dime size).

--Factor is two.

--A maximum of one incident per carcass.

2 Breast blister--partially trimmed

--All inflammatory tissue, including that which adheres tightly to the keel bone, must be removed.

--Factor is one.

--A maximum of one incident per carcass.

3 Bruise 1/2" -1"

--Blood clumps or clots in the superficial layers of tissue, skin, muscle or loose subcutaneous tissue may be slit and the blood completely washed out. When the bruise extends into the deeper layers of muscle, the affected tissue must be removed. Very small bruises less than 1/2" (dime size) and areas showing only slight reddening need not be counted as defects.

--Factor is one.

--A maximum of five incidents per carcass.



(§ 381.76(b)(3) continued)

4 Bruise >1"

--Same criteria as in line three, but greater than one inch in greatest dimension.

--Factor is two.

--A maximum of three incidents per carcass.

5 Bruise black/green 1/4" to 1"

--Bruises 1/4" to 1" that have changed from red to a black/blue or green color due to age.

--Factor is two.

--A maximum of three incidents per carcass.

6 Bruise Black/green >1"

--Same as line 5, but measuring greater than 1" in greatest dimension.

--Factor is five.

--A maximum of two incidents per carcass.

7 Trimmable lesions/Condition

--A trimmable tumor or identifiable portion of a tumor on any part of the carcass.

--Trimmable synovitis/airsacculitis (saddle/frog) lesions that have not been removed.

--Lesion/condition subject to removal following an approved cleanout process. Examples: airsacculitis, salpingitis, nephritis, spleen, or liver conditions requiring removal of the kidneys.



United States Department of Agriculture  
Food Safety and Inspection Service  
*Room 0157-South Building*  
Washington, DC  
20250

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